

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77467

December-08-11 8:00:12 AM

77467

Page 2

Item ID: D2989-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid Assembly

Start Date: 08/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

S 11/12/14

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

X of M-11/12/16

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Page 3

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 08/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 20/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	1ST COAT								
	START TIME: 10:30								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 11:00								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

1X M-11/12/16

M119480

1 BR 11-12-19

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid Assembly
Start Date: 08/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 20/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
150									
Packaging	Memo <i>w/o</i>	0.00							
Packaging	<i>77465</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SP 11/12/2011

11/12/2011

11-12-2011
CD

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December-08-11 8:00:16 AM

77467

D2989-043

Required Date: 20/12/2011

Required Qty: 1.00

IPP Rev:J Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	16.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA006				16					
				71372				4					
				72297				12					
D2989-3 *D2989-3* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA005				4					
				71551				1					
				72408				3					
D2989-4 *D2989-4* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA005				4					
				71550				1					
				72409				3					

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Picklist Print

December-08-11 8:00:16 AM

Page 2

Work Order ID: 77467

77467

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-5 Manufactured No

100 Each 9.0000 2 2

D2989-5

Rib

**

Pl 11.12.13

Location	Loc Qty	Loc Code
WA005	9	
(71222)	9	(2)
	100	Each 2.0000 2 2

D3182-1 Manufactured No

D3182-1

Hinge

**

Pl 11.12.13

Location	Loc Qty	Loc Code
WA005	2	
71223	2	
	100	Each 7.0000 2 2

376657 → (2)

D3442-3 Manufactured No

D3442-3

Shim

**

Pl 11.12.13

Location	Loc Qty	Loc Code
WA005	7	
(70671)	7	(2)
	100	Each 9.0000 1 1

D3827-041 Manufactured No

D3827-041

Rib Assembly (Inboard)

**

Pl 11.12.13

Location	Loc Qty	Loc Code
WA006	9	
72083	3	
(72729)	6	(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

December-08-11 8:00:16 AM

Page 3

Work Order ID: 77467

77467

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3832-5

Manufactured No

100

Each

5.0000

1

1

D3832-5

Mesh (Lid)

**

Pl 11.12.13

Location

Loc Qty

Loc Code

WA

5

71302

2

73638

3

48.0000

2

2

D3833-5

Manufactured No

100

Each

**

Pl 11.12.13

D3833-5

Mesh (Lid End)

Location

Loc Qty

Loc Code

WA

48

67461

48

4.0000

1

1

D3838-041

Manufactured No

100

Each

**

Pl 11.12.13

D3838-041

Rib Assembly (Basket Lid, LH)

Location

Loc Qty

Loc Code

WA

4

71744

1

72414

3

4.0000

1

1

D3838-042

Manufactured No

100

Each

**

Pl 11.12.13

D3838-042

Rib Assembly (Basket Lid, RH)

Location

Loc Qty

Loc Code

WA

4

71740

1

72415

3

4.0000

1

1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77467 M.C.J
11/12/08

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6	1		D2989-3	RIB
7	1		D2989-4	RIB
8	2		D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12	2		D3182-1	HINGE
13	2		D3442-3	SHIM
14	1		D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16	1		D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18	2		D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21	1		D3838-041	RIB ASSY (BASKET LID, LH)
22	1		D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 TITLE BASKET LID ASSEMBLY REV. D SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	DS		
CHECKED	AJS		
MFG. APPR.	MD		
APPROVED	MD		
DE APPR.	MD	DATE 08.09.24	

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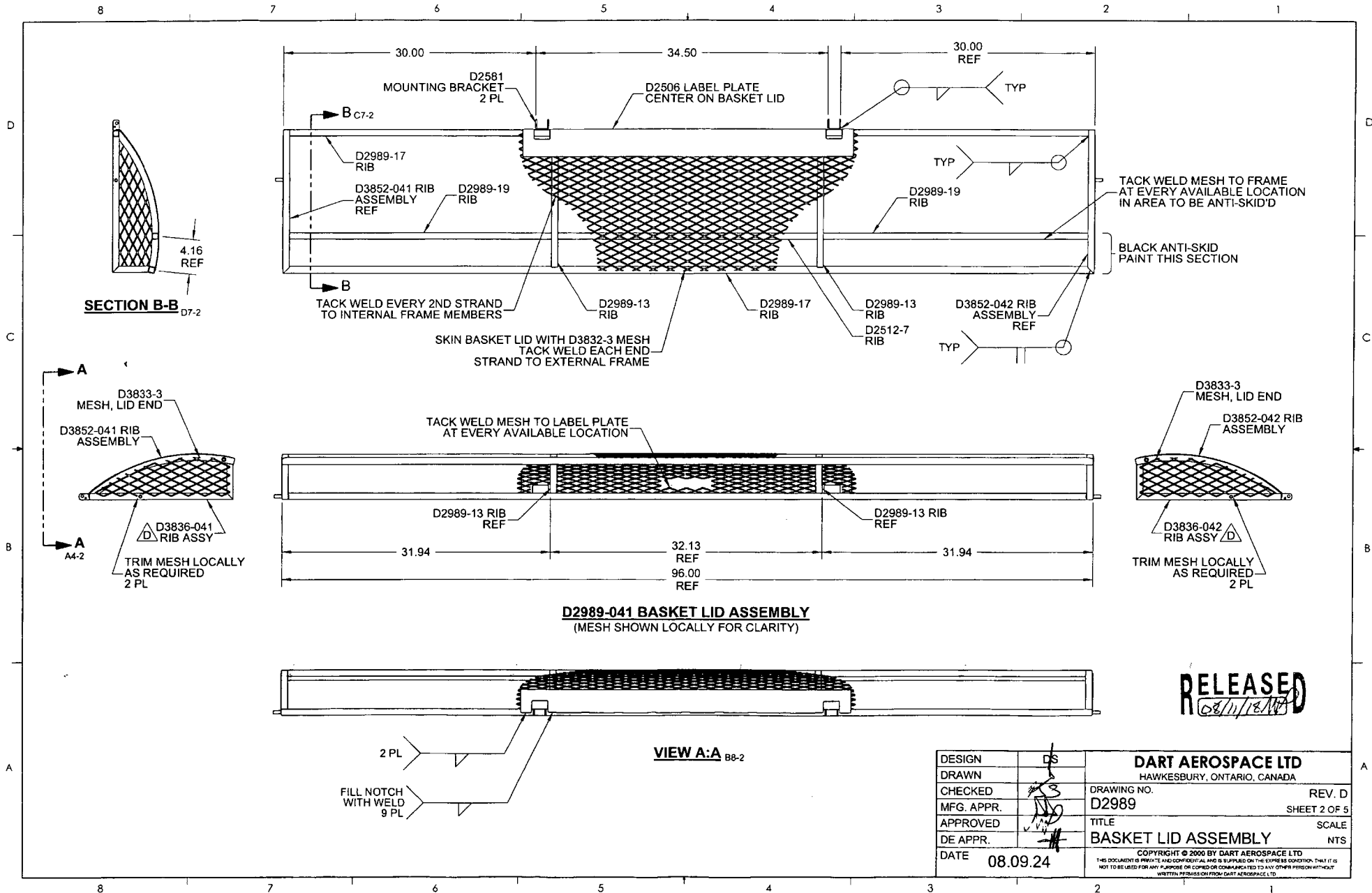
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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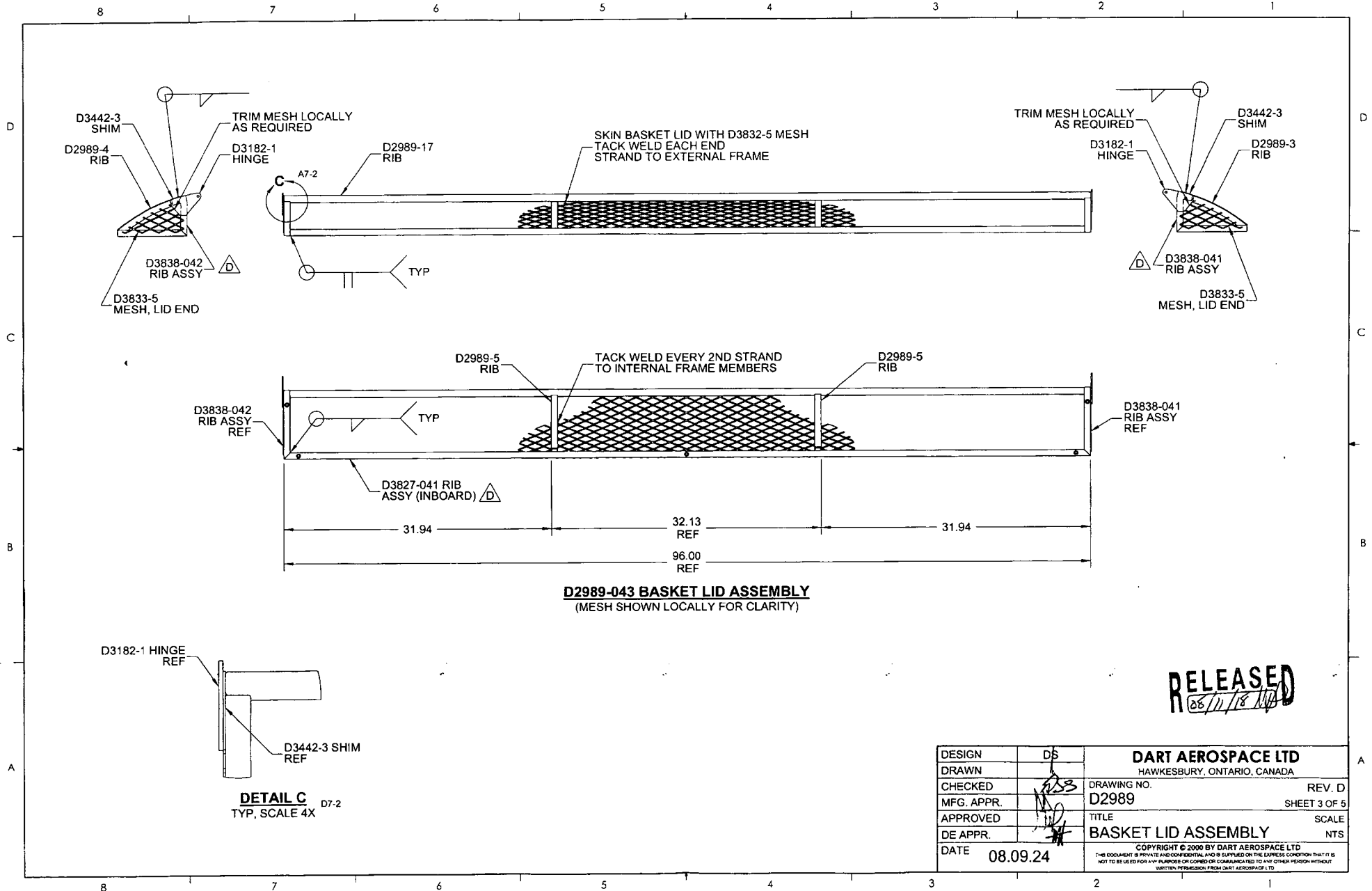
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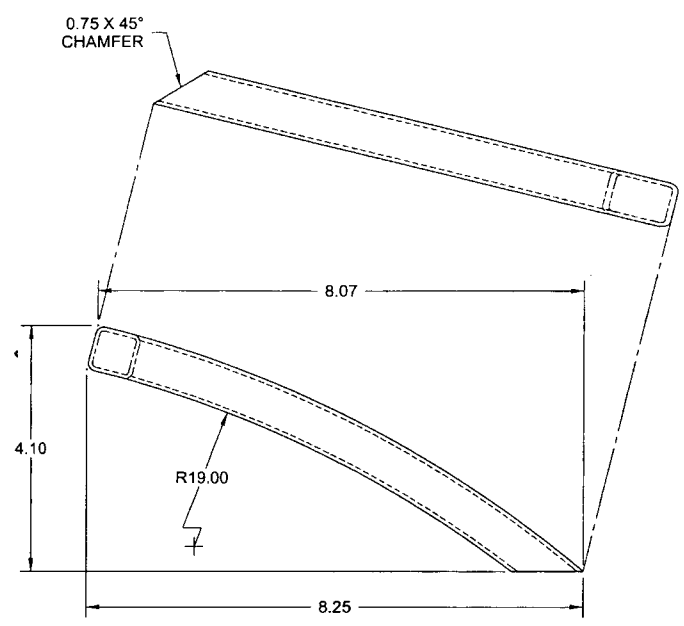
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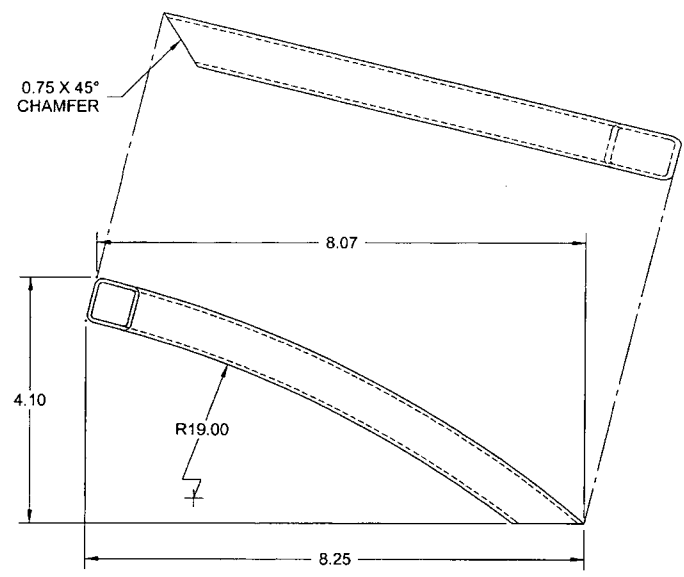
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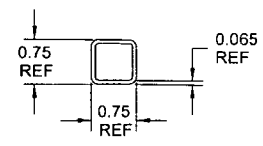
77467



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		BASKET LID ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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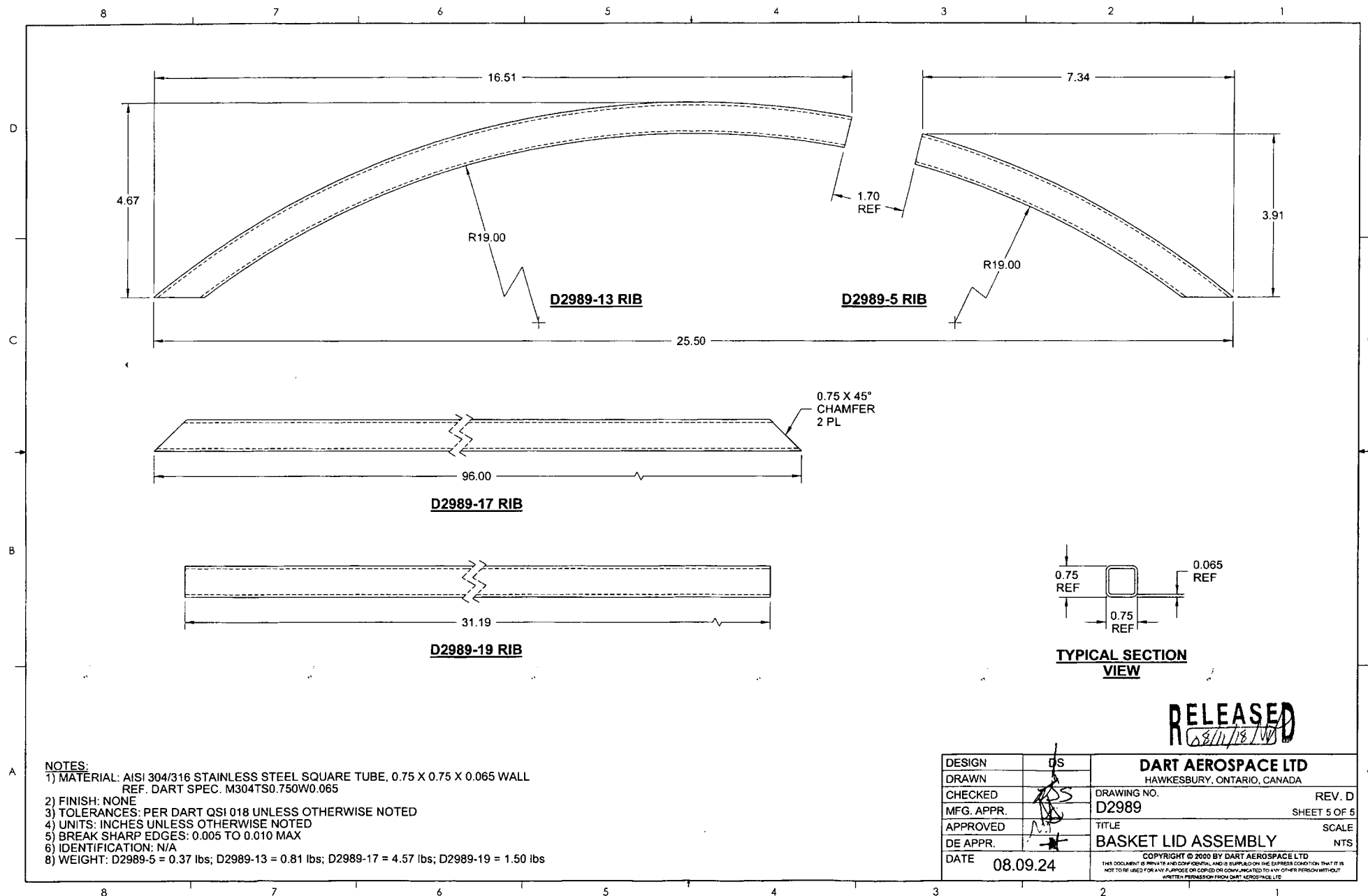
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